

Bench vise Kit Installation Instructions



The first thing to do is install the **Vise Jaw Adapter**.



Clamp the **Vise Jaw Adapter** in your vise. Make sure the top of the adapter is flush with the top of the bench rather than the vise. The bench top is the reference point.

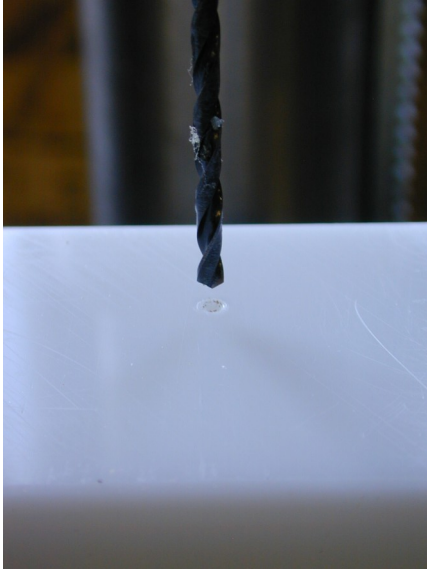


Make sure that the pivot hole in the block is centered on your bench top's line of bench dog holes. Clamp the vise tight to hold the **Vise Jaw Adapter** while performing the next step.



Mark the center of the jaw accessory holes on the front of your vise with either a transfer pin or a drill bit of the same size as the holes in your vise jaw. Do not drill through the adapter at this point. Just mark the surface of the **Vise Jaw Adapter**.

If your vise does not have mounting holes, drill those first.

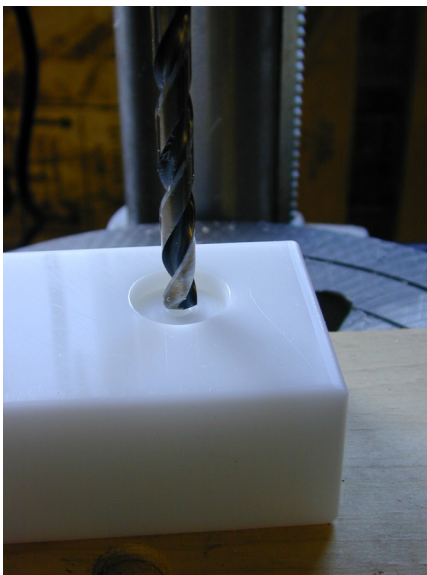


Using a drill press, drill a 1/8" hole through the **Vise Jaw Adapter**. If you have more than one vise with holes that are spaced differently, you can drill holes for both vises by turning the adapter upside down.

NOTE: If you would prefer a simpler method of mounting the **Vise Jaw Adapter**, you can drill a 5/16" hole at this point and avoid the counter boring procedure. This would leave the "T" nuts above the surface of the **Vise Jaw Adapter**, instead of flush. This might interfere with your work if you leave the adapter in the vise.



If you are going to counterbore use a 7/8" Forstner or Brad Point bit, to counter bore approximately 3/16" deep. The depth is not critical, just make sure the surface of the "T" nut is below the surface of the **Vise Jaw Adapter**.



Using a 5/16" twist drill bit, drill thru the **Vise Jaw Adapter**. You can use a counter sink to clean up the opposite side where the drill exits.



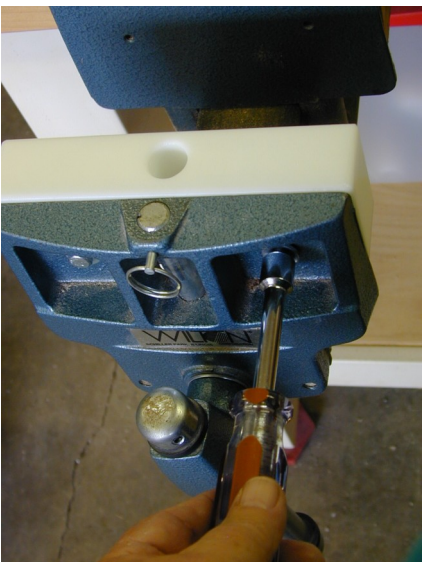
Using the head of a 1/2" bolt, set the T-nut in the counterbore. Strike the end of the bolt sharply until the T-nut is set.

NOTE: Do not press the T-nuts in with the vise or a press. The prongs will bend. The sharp rap of a hammer and punch will prevent this.

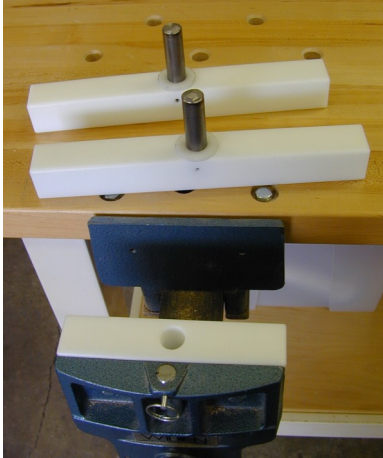


Insert the included 1/4"-20 hex bolt and washer through the front vise jaw and **Vise Jaw Adapter** and hand thread into the T-nut.

NOTE: Make sure the T-nut is at the back of the **Vise Jaw Adapter**, facing the fixed jaw, and not pressed against the vise jaw itself.



Tighten the bolt firmly using a 7/16 nut driver. The thickness of vise jaws vary from one maker to another. If the bolt protrudes from the **Vise Jaw Adapter**, use additional washers under the head of the hex bolt to bring it flush with the T-nut, or use a shorter bolt.



Slip the included **Anti-friction** washers over the pivot pins on the pivot arms.



Install the **Pivot Arms**. Place one in the **Vise Jaw Adapter** and the other in the appropriate bench dog hole to fit the item to be clamped.



Place the included **Grip Pins** in the appropriate holes to make contact with the object to be held. The **Grip Pins** can be placed in any hole that makes contact, but make sure your object is placed so that it is centered in the vise. Those items placed to one side or the other may not be held securely.

NOTE: The Grip-All Jaws System requires 3/4" diameter bench dog holes perpendicular to your front vise. The dog holes should be spaced per the included diagram. The bench dog holes **MUST** be drilled at a right angle to the bench surface. **THIS IS IMPORTANT!** Use a Port-A-Line jig or a shop-built jig to guide the drill bit perfectly perpendicular to the bench surface. A drawing is included for a jig to drill the bench holes perpendicular to the bench top. Use a round-over or chamfering bit in a router to finish the edge of the dog holes.